

Work Order ID 68258

Monday, April 11, 2011 10:33:18 AM

Page 1

Item ID: D3417-9

Accept

Setup Start

Revision ID:

Stop

Item Name: Washer

Start Date: 4/11/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3417

F

100

0.00



Doosan

Hardinge CNC LATHE SMALL

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA954

Folio Rev: FA

Dwg D3417 Rev: F

2-Deburr

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68258

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Page 2

Item ID: D3417-9

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 4/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

amf 11/04/15

30

0

130 Identify as per dwg & Stock Location: S3

0.00



Packaging

Memo

0.00

Packaging

11/4/19 SD 300

140 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19 JG

11/04/19

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Picklist Print

Monday, April 11, 2011 10:33:25 AM

Page 1

Work Order ID: 68258

Parent Item: D3417-9

Parent Item Name: Washer



Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: Ipp Rev:A New Issue 10-08-03 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500		Purchased	No				f	22.7500		0.934731			
DELIN ROUND BAR 1.25"													

11.4.15

Location

MAT055

Loc Qty

22.75

Loc Code

114586

22.75

1.

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

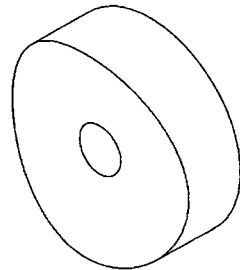
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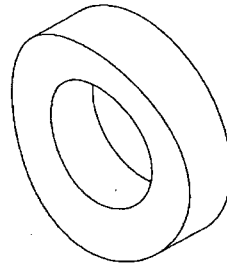
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68258

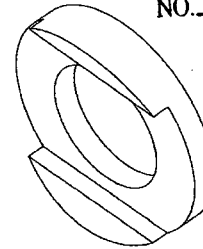
RP17-04-11



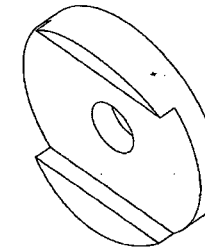
D3417-1 WASHER



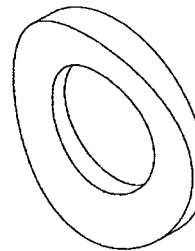
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

RELEASED
2010-09-15
mm

NOTES:

1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELIN-S

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D3417-1, 0.020 lbs

D3417-3, 0.010 lbs

D3417-5, 0.010 lbs

D3417-7, 0.010 lbs

D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.08.30
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO 'B' SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE BORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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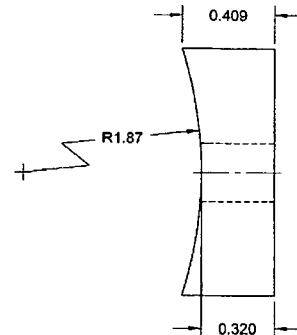
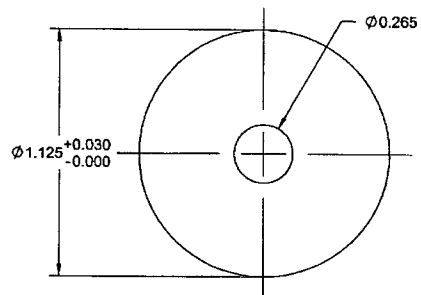
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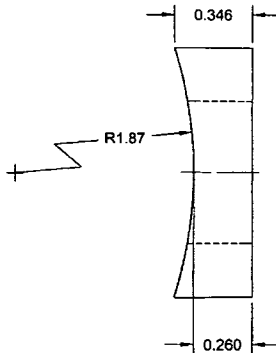
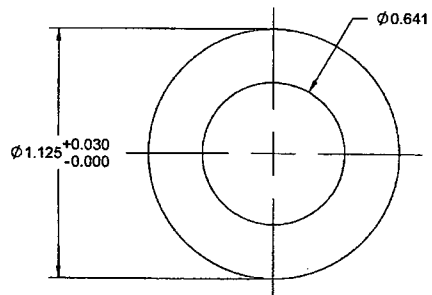
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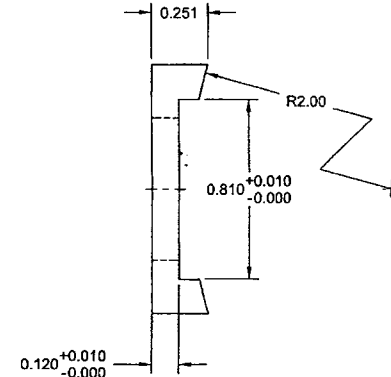
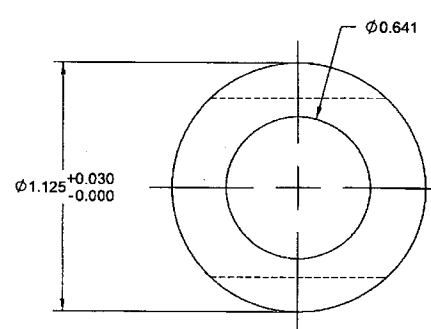
W/O 48258



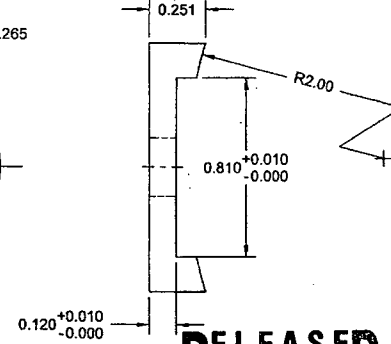
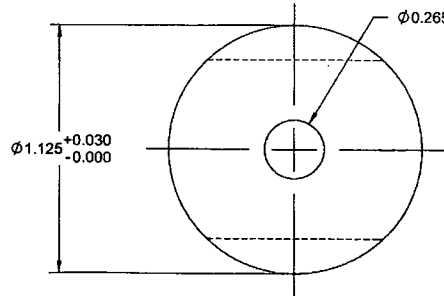
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

RELEASED
2010-09-15

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DRAWN	SC		
CHECKED		DRAWING NO. D3417	REV. F
MFG. APPR.		TITLE	SHEET 2 OF 3
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DE APPR.			NTS
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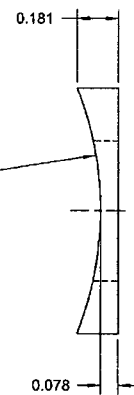
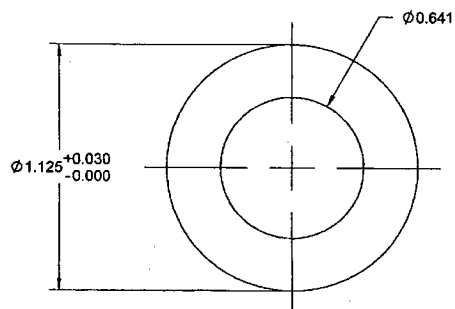
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u/b 68258

D3417-9 WASHER



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